

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011935**Date Inspected:** 18-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

IN PROCESS INSPECTION:-**TOWER TRAIL ASSEMBLY AREA:-****NORTH SHAFT LIFT 1:-**

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: NSD1-SA76F/G-41 located on Skin E Bearing Plate. Welder is identified as 068047.ZPMC QC is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: NSD1-SA17F/G-59 located on Skin C Bearing Plate. Welder is identified as 040343.ZPMC QC is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

WEST SHAFT LIFT 1:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WSD1-SA279-24 located on Skin B Bearing Plate. Welder is identified as 068858.ZPMC CWI is identified as Mr. Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

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This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WSD1-SA225F/H-51 located on Skin E Bearing Plate. Welder is identified as 068765.ZPMC CWI is identified as Mr. Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WSD1-SA225F/H-27 located on Skin E Bearing Plate. Welder is identified as 053486.ZPMC CWI is identified as Mr. Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA Inspector carried out the measurements on strut plate for flange to flange, bolt hole distance, stiffener to stiffener, 10mm to CJP. The measurements carried out wherever accessible and recorded on the data sheet and submitted to the task leader. The members are identified as Tower Components. The member designations reviewed are as follows:-

WD1-A467-38M-1,2,3,4

WD1-A468-38M-2

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai, Pandaram	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
